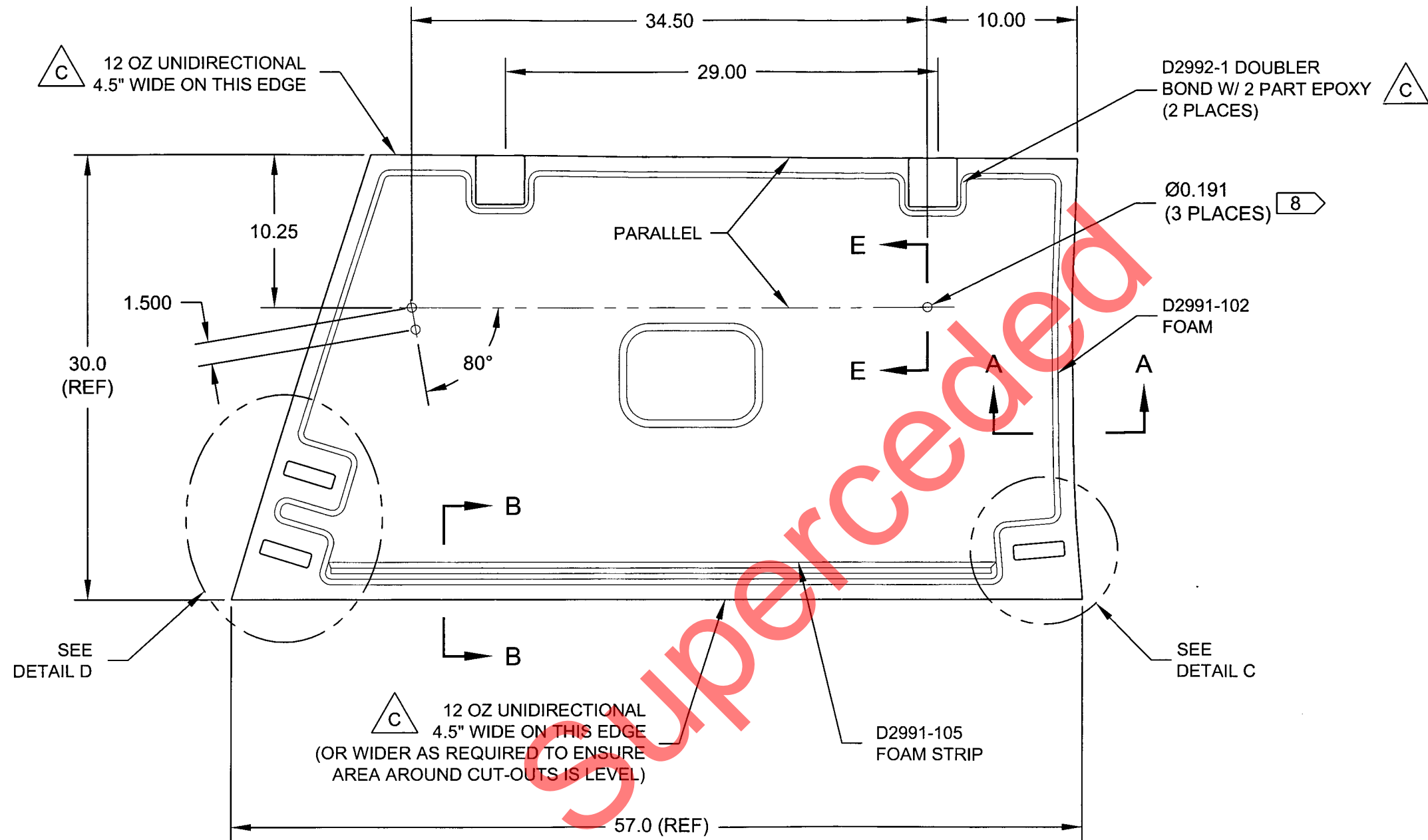


D2991-1 SIDE DOOR

UNDER REVIEW
09/03/18

RELEASED
01.12.21

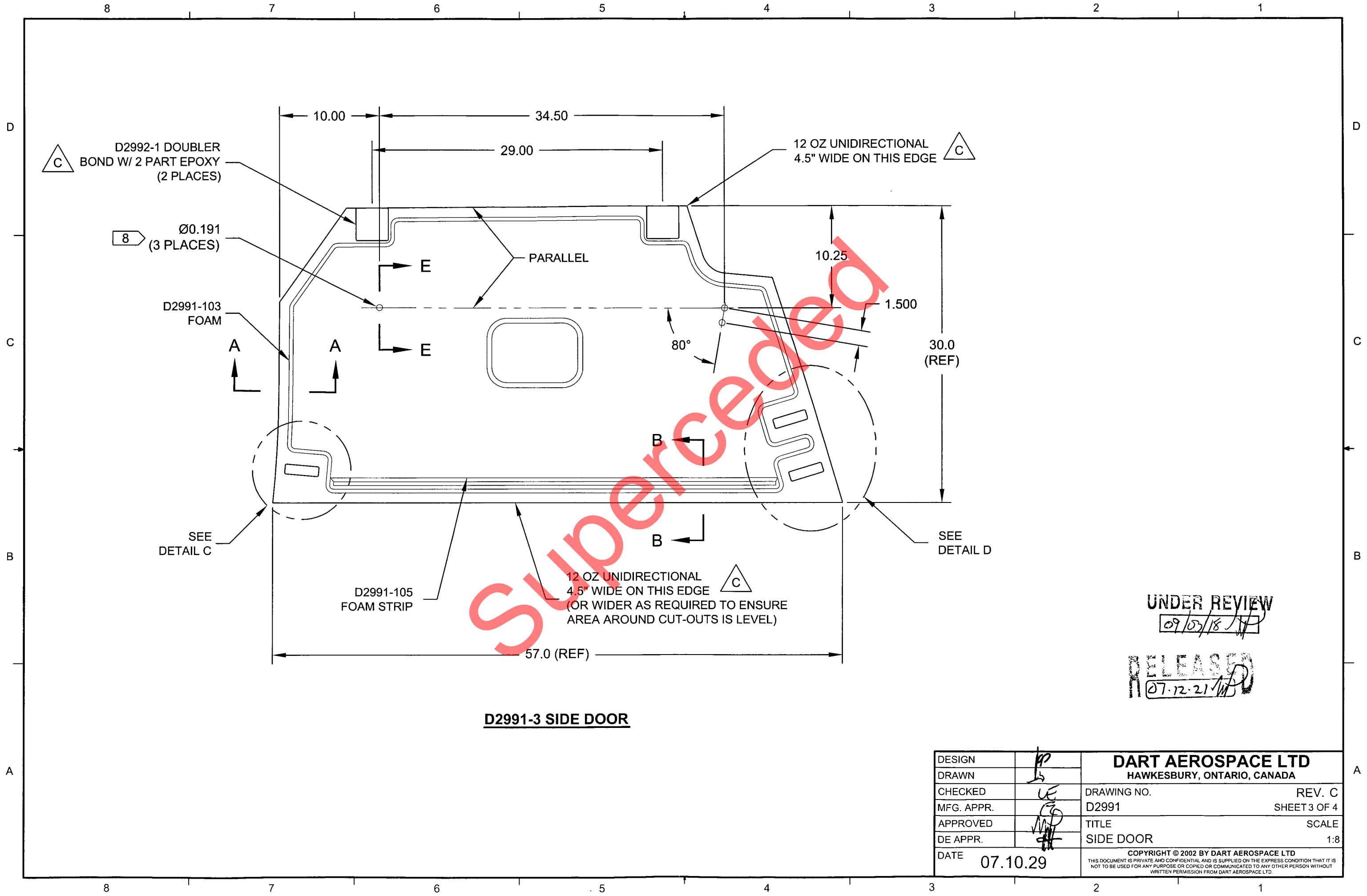
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
DESIGN	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	LE	DRAWING NO.	REV. C
MFG. APPR.	GP	D2991	SHEET 1 OF 4
APPROVED	GP	TITLE	SCALE
DE APPR.	GP	SIDE DOOR	1:8
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D2991-2 SIDE DOOR

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 07-12-21

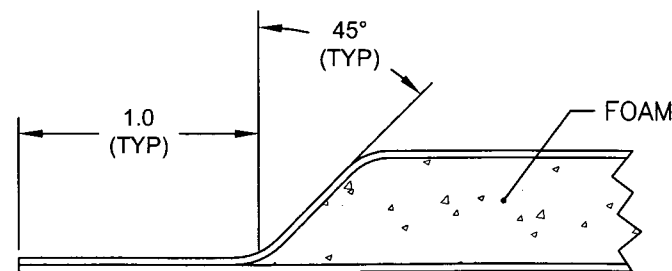
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MFG. APPR.		D2991	SHEET 2 OF 4
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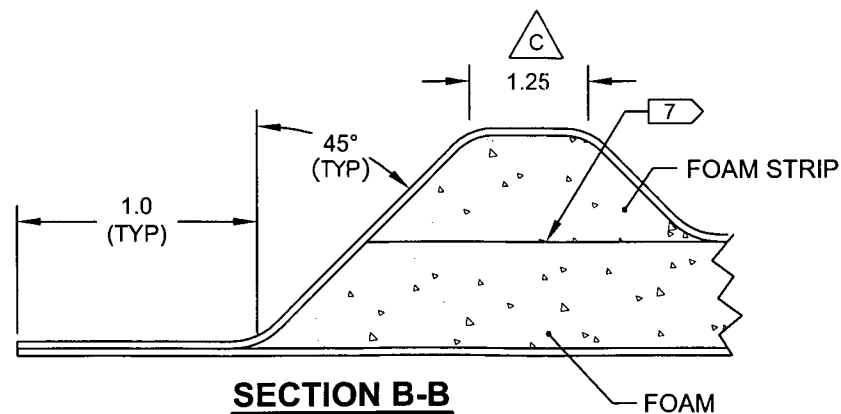
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DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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MFG. APPR.	<i>[Signature]</i>	D2991	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR	1:8
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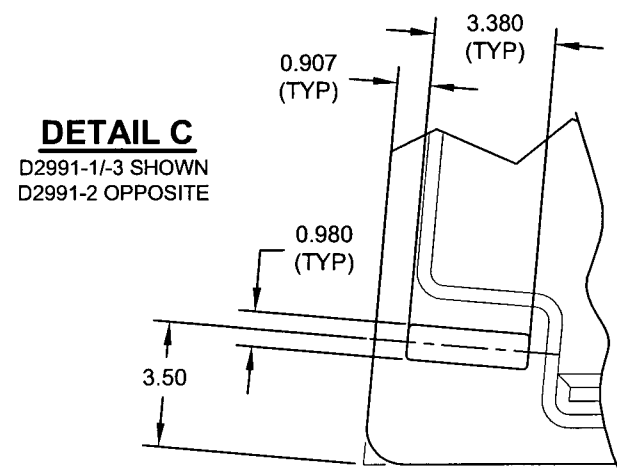
SECTION A-A

NOT TO SCALE
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



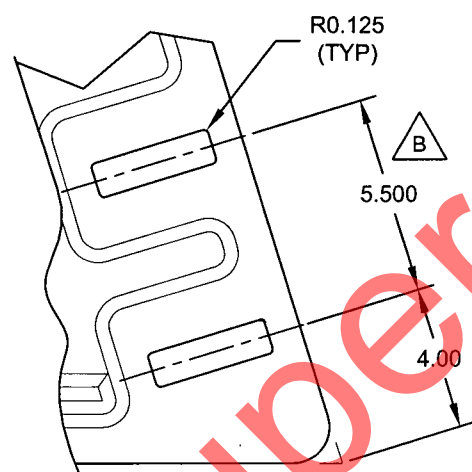
SECTION B-B

ONE EDGE ONLY
NOT TO SCALE, VIEW ROTATED
D2991-1/-3 SHOWN
D2991-2 OPPOSITE



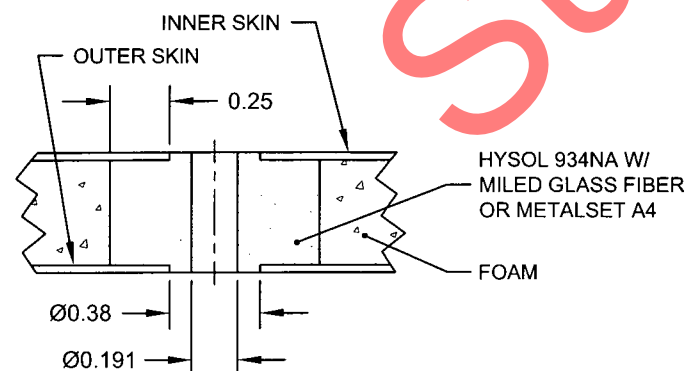
DETAIL C

D2991-1/-3 SHOWN
D2991-2 OPPOSITE



DETAIL D

D2991-1/-3 SHOWN
D2991-2 OPPOSITE









SECTION E-E

TYPICAL Ø0.191
HOLE DETAIL
NOT TO SCALE

NOTES FOR D2991-1/-2/-3

- LAYUP PER QSI 006 AND AS FOLLOWS
- MATERIALS:
RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- USE MOLD DT8626 FOR D2991-1 SIDE DOOR
USE MOLD DT8627 FOR D2991-2 SIDE DOOR
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR
DT8629 FOR D2991-2 SIDE DOOR
DT8630 FOR D2991-3 SIDE DOOR
- MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005
9 OZ SATIN
9 OZ SATIN
FOAM
FOAM STRIP
9 OZ SATIN
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)
9 OZ SATIN
RESIN (35-45% BY WEIGHT)
PEEL PLY
- BOND FOAM CORE USING POLYBOND B46F
- DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1 OR METALSET A4. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: PER D2991-1/-2/-3 PPPs.
- WEIGHT: 9 lbs (TYP)

UNDER REVIEW
09/03/18
RELEASED
07.12.21

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2991	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SIDE DOOR	1:5
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